

Work Order ID 94826

94826

Page 1

December-20-12 9:16:45 AM

Item ID: D3913-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 12/21/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-01-13

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	B								
100		0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- Cut tube as per dwg D3913 2- Drill hole as per dwg ***one side only*** 3- remove identification marks and deburr								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location:	0.00							
120									
Packaging	Memo	0.00							
Packaging									

6x 12-13-05

6x 13-03-06

6x 13-03-06

Work Order ID 94826

94826

Page 2

December-20-12 9:16:45 AM

Item ID: D3913-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib

Start Date: 12/21/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

13/3/12

RB-03-6

Picklist Print

December-20-12 9:16:45 AM

Page 1

Work Order ID: 94826

Parent Item: D3913-1

Parent Item Name: Rib

Start Date: 12/21/12

Required Date: 1/11/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B add drill one side only
DD 10.04.12 verified by:EC IPP Rev:C 11.01.18 chg qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	905.1312	8	8.4210526			
304 SQ Tube .75x.75x.049W													

Location

Loc Qty

Loc Code

MAT017

2.0156214

121898

2.0156214

WA006

903.1155859

122201

0.1626

122425

39.0000000

122666

0.7293

122710

20.5

123219

289.5

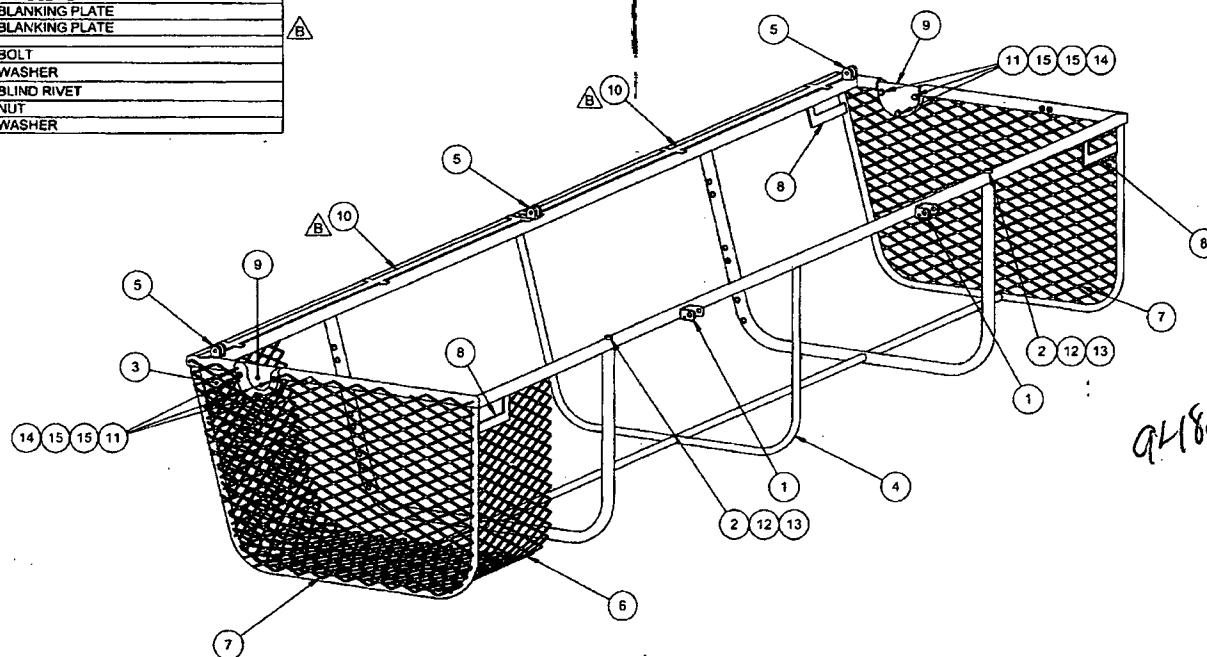
123484

553.223686

50.53

6X DL 13-03-05

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	BLIND RIVET
14	6	MS21042L3	NUT
15	12	NAS1149F0332P	WASHER



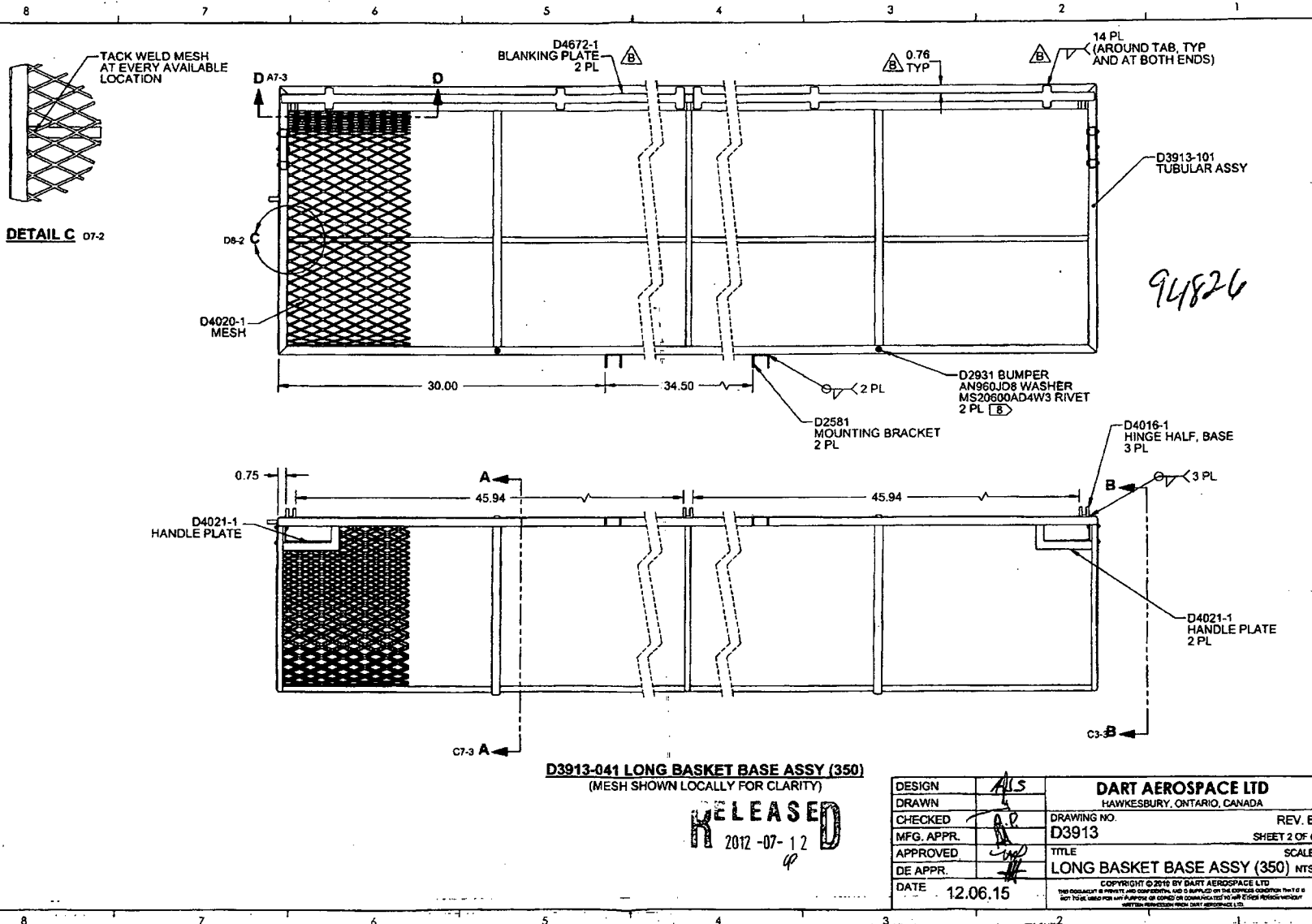
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

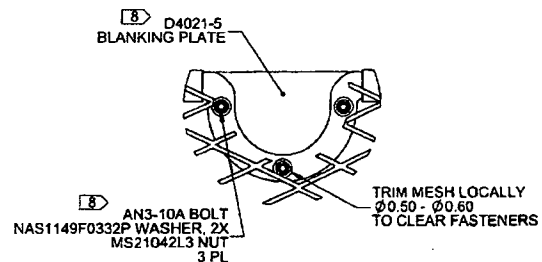
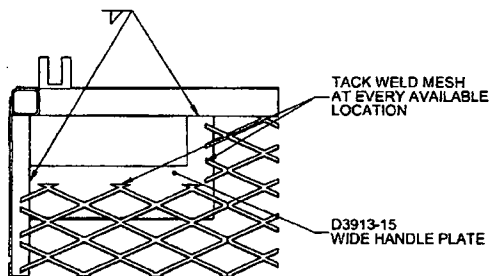
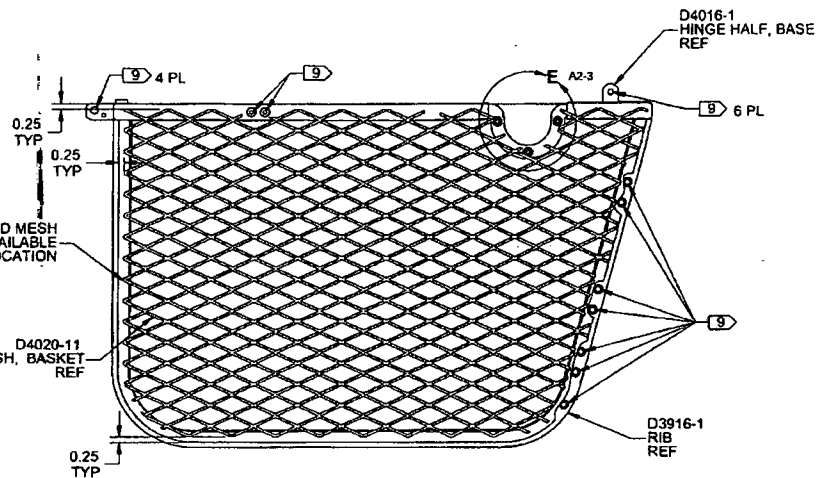
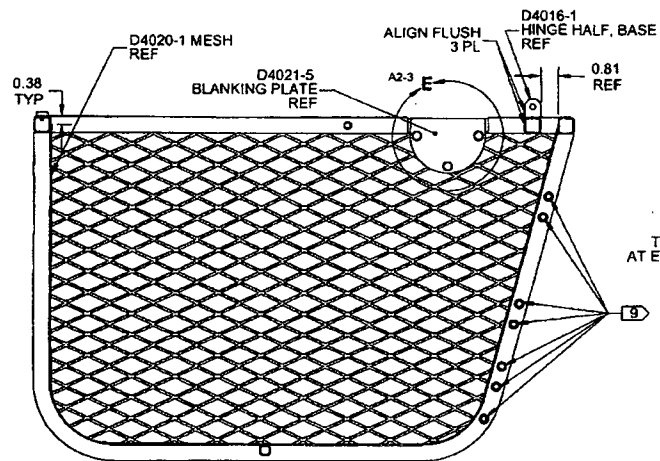
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005.4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2012-07-12
UP SCN 12-64

B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2).	MB	12.05.15
A	REASON: PART 12-187.	JPH	10.03.16
REV.	NEW ISSUE	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS	DRAWING NO.	REV. B
CHECKED	AS	D3913	SHEET 1 OF 6
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AS	LONG BASKET BASE ASSY (350) NTS	
DE APPR.	AS	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.06.15		

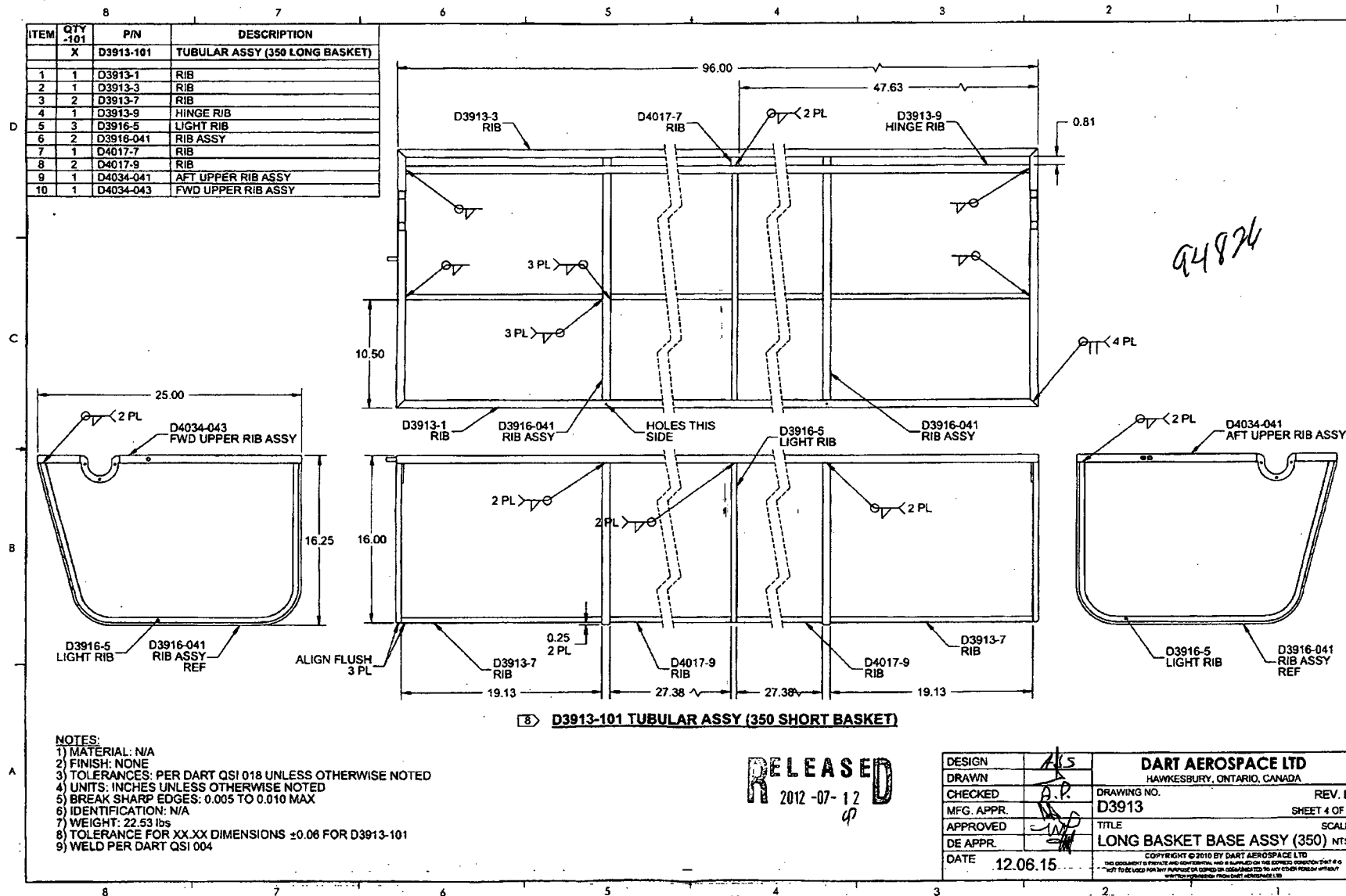




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2012-07-12
up

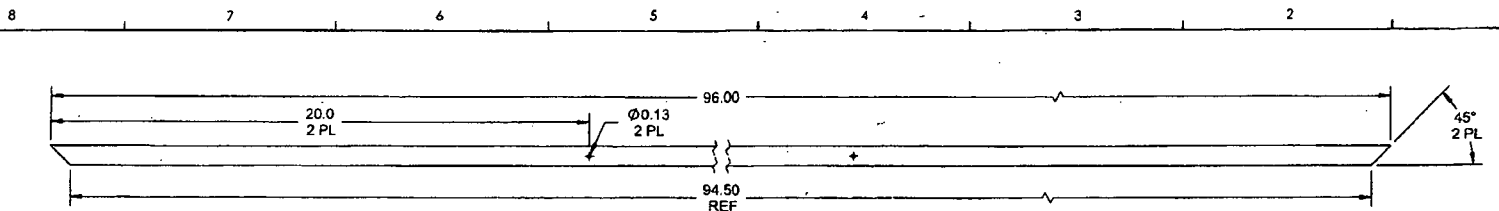
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DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	ALS	D3913	SHEET 3 OF 6
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	LONG BASKET BASE ASSY (350)	NTS
DATE	12.06.15	COPYRIGHT © 2015 BY DART AEROSPACE LTD	
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY

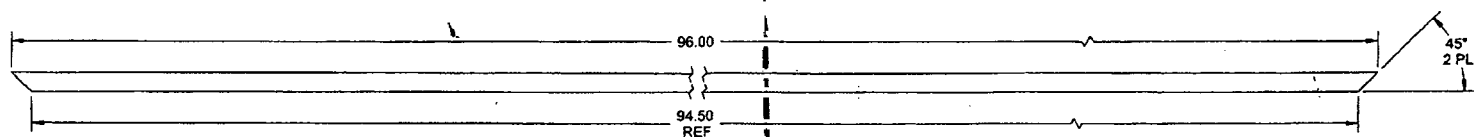


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2012-07-12
4

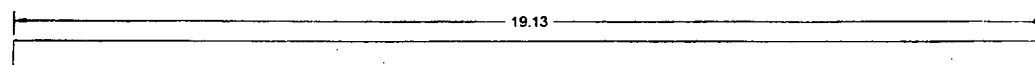
DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	12.06.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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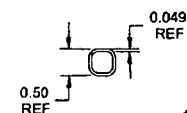
D3913-1 RIB



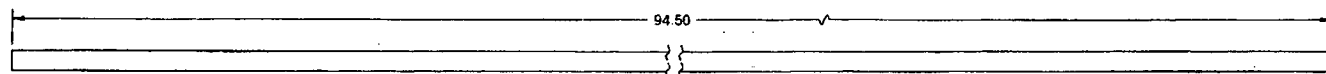
D3913-3 RIB



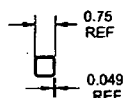
D3913-7 RIB



Q41826



D3913-9 HINGE RIB



NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

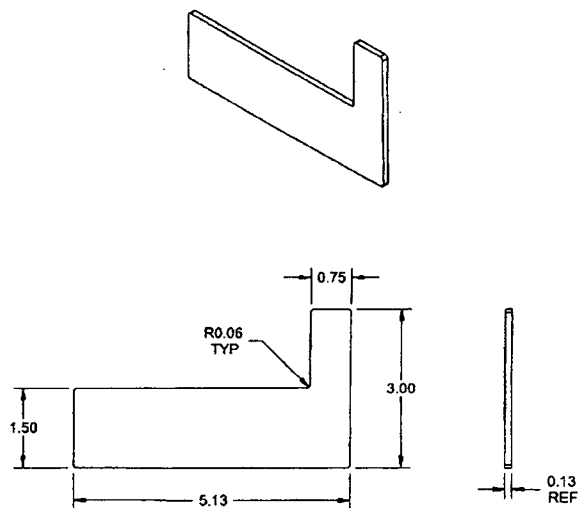
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2012-07-12
UP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>D.P.</i>	DRAWING NO.	REV. B
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY (350) NTS	
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D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH.
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2012-07-12
P

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	R.P.	DRAWING NO.	REV. B
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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Receiving Report

Date:

12/10/29

Batch No:

1212 3489

Supplier:

Metaxs d. H. J.

Dart P/O:

18214

Packing Slip:

Yes ☒

No ☐

Invoice:

Yes ☒

No ☐

Receipt:

Cash ☐

Cr ☒

Release Note Attached:

Yes ☒

No ☐

N/A ☐

Waybill Attached:

Yes ☒

No ☐

N/A ☐

Shipment Complete:

Yes ☒

No ☐

N/A ☐

QC6 Inspection

12/11/21

N/A ☐

Work Order

12/11/21

N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

12/12/29
[Signature]

Location

Purchase Order Receipt Listing

Page 1 of 1

Monday, October 29, 2012 9:29:38 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO18214 All Receipt Dates All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
---------------------------------	--------------------------	------------	--	-----------------------	-------------------------------	------------------------	----------------------	------------------------------	--	----------------------------	----------

VendorID/Vendor Name		VC-MET002	Metaux Solutions								
PO18214	1		M304TS0.750W.049 f		10/29/2012	10/29/2012	600.0000	\$3.86	0.0000	0	\$2,318.99
CAD	No		304 SQ Tube .75x.75x.049W 123484	f	600.0000	DESJ02		\$2,318.99	0.0000	0	

Total Received Quantity: 600.0000

Total Qty to Inspect (PO U/M): 0.0000

Total Reject Quantity: 0.0000

Total Receipt Value: \$2,319.00

Total Balance Due Quantity: 0.0000

MÉTAUX SOLUTIONS INC
2625 BOUL JACQUES CARTIER EST
LONGUEUIL, QUEBEC
J4N 1L7 Tel : 450 641-3330

Shipping Order 25/10/2012

Order : 82133
Reference : PO18214
Ship : PICK UP / PICK UP

Customer : 6323336

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

Ship To

Same

Tel.: 1 613 632-3336

Item No.	Description	Qty	Qty. Delivered	B/O Qty
SSQT34340484	304 SQ TUBE .750 X .049 WALL 30 X 20' HT,C5P3	600	600	0

SHIP TST COLLECT
JP

DAS
14
2-8 12/11/01

[Handwritten signature]

Shipping : _____

Package No : _____

Merchandise Received: _____

Ref. : _____

PHOENIX TUBE COMPANY, INC.
 Manufacturer of Stainless Ornamental and Structural Tubing
CERTIFICATION OF TEST

Sold To:

Ship To:

CUSTOMER ORDER# C85485

CUST REF NBR:

DATE SHIPPED: 10/22/12

SIZE: 3/4SQ X 18 GA AW

SOURCE: USA D

VENDOR: NAS

Phone# 5492803

Ext:

ORDER# 288601

QTY SHIPPED: 1620.0

GRADE: 304L

WELD: HF

FEAT#: C6P3

TEST REPORT# TR010484

Report Date: 07/11/12

Specification:

ASTM A584-11

ASTM A 240 LATEST REVISION

ASTM A554 2003 SUPERSEDED

MATERIAL IS FULL SOLUTION

DFARS 252.225-7009/7014

T304L/304 DUAL CERTIFIED

RAW MATERIAL SPEC.

MFG USING

ANNEALED, AND SHOWS NO
COMPLIANT

NO WELD REPAIR

ANNEALED AND PICKLED
CONTINUOUS CARBIDE

EN 10204 2.2

NACE MR017501

PLATE, SHEET OR STRIP
PRECIPITATION

DAS
14
2-89 12/11/01

MERCURY IS NOT USED BY US AS AN ALLOYING MATERIAL NOR IS METALLIC MERCURY HANDLED IN THE VICINITY OF OUR PROCESSING LINES. WE ARE NOT PRESENTLY AWARE OF ANY MERCURY CONTAMINATION.

Chemical Analysis

C	MN	P	S	SI	CR	NI	MO	CU	CO	N2	TI
.021	1.77	.032	.012	.27	18.22	8.08	.33	.43	0	.08	0

Physical Analysis

Hardness	YIELD		TENSILE		OTHER	
	PSI	MPA	PSI	MPA	Percent EL	Percent RA
RB 86	50480	0	96110	0	45	0

THE CHEMICAL ANALYSES ARE CORRECT AS CONTAINED IN OUR CORPORATE RECORDS.

PHYSICAL PROPERTIES ARE DETERMINED WHILE MATERIAL IS IN STRIP FORM.

Melted & Manufactured in the USA FAR BAA complies, DFARS BAA complies, FAR TAA complies

CERTIFIED BY:

John L. Leno

1185 WIN DR, BETHLEHEM, PA., 18017 - (610) 865-5337

FAX NUMBER: 610-865-4073

149135



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO18214

Purchase Order Date 10/23/2012

PO Print Date 10/29/2012

Page Number 1 of 1

Order From :

METAUX SOLUTIONS
2625 BOUL JACQUES-CARTIER EST
LONGUEUIL, QC J4N 1L7
CA

VC-MET002

REFERENCE ONLY

Contact Name

Vendor Phone 800 558 8858

Vendor Fax 514 633 8044

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304TS0.750W.049	304 SQ Tube .75x.75x.049W	10/29/2012 Yes	600.00 f	TST ground	\$3.8000	\$2,280.00

Special Inst: AISI 304/316 SEAMLESS SS
SQUARE TUBING
ASTM A554 MILL FINISH OR
ASTM A269 MILL FINISH

PO Total:

\$2,280.00

REFERENCE ONLY

Change Nbr: 1

Change Date: 10/23/2012

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO